

Date: Tuesday, 07/10/2008 10:16:39 AM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LEFT ARM WELDMENT
Job Number :	42495		
Estimate Number :	12080		
P.O. Number :		Part Number :	D33543
This Issue :	07/10/2008	Drawing Number :	D3354 REV C
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	//	Drawing Revision :	C
Previous Run :	36649	Material :	
Written By :		Due Date :	30/10/2008
Checked & Approved By :	<u>JUD 28-10-07</u>	Qty:	10 Um: Each
Comment :	est rev A 06.01.23 new issue EC Est Rev:B 07-12-10 rev C dwg DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M4130NR1250	4130N ROUND BAR 1.250
-----	-------------	-----------------------



Comment: Qty.: 0.6300 f(s)/Unit Total : 6.3000 f(s) M106961 x 5
 AISI 4130 ROUND BAR 1.250" dia. batch: 44106 M103433 x 3

mme 08/10/16

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: 1-TURN AS PER FOLIO FA623 & DWG D3354

FOLIO REV: B
 DWG REV: C

2-DEBURR AS REQUIRED

mme 08/10/16

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mme 08/10/16

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

1-Drill cotter pin hole as per dwg D3354

2-Debur

mme 08/10/17

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.A. 08/10/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 07/10/2008 10:16:39 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEFT ARM WELDMENT

Job Number: 42495

Part Number: D33543

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



8x

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Cart

8/10/20

SP

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/20

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-10-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Wheel Shaft		Part Number:	D3354-3
Inspection Dwg: D3354	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.04	+/-0.030	7.04	✓			
4.020	+0.010/-0.000	4.025	✓			
0.85	+/-0.030	.84	✓			
0.06	+/-0.030	.06	✓			
0.13	+/-0.030	.14	✓			
Ø1.250	+0.001/-0.004	Ø1.248	✓			
Ø1.103	+0.001/-0.002	Ø1.102	✓			
0.750 Thread	+/-0.010	.750	✓			
0.03 x 45°	+/-0.030 x 0.5°	.03 x 45°	✓			
Ø0.152	+0.005/-0.001	Ø.152	✓			
R0.02	+/-0.030	R.02	✓			
R0.050	+/-0.010	R.050	✓			
0.660	+/-0.010	.658	✓			

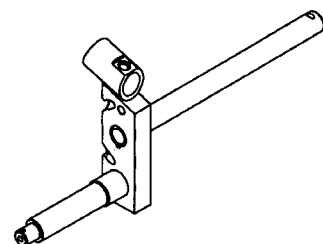
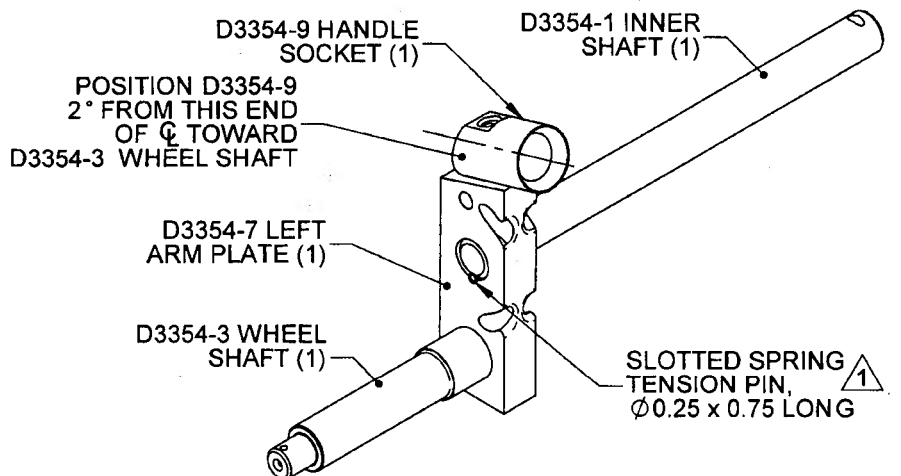
Measured by: <i>MMF</i>	Audited by: <i>H.A</i>	Prototype Approval:	N/A
Date: <i>08/10/17</i>	Date: <i>08/10/17</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	07.04.20	Ø0.152 dimension removed.	KJ/JLM	
C	08.01.16	Dwg Rev updated	KJ/EC/DD	<i>[Signature]</i>



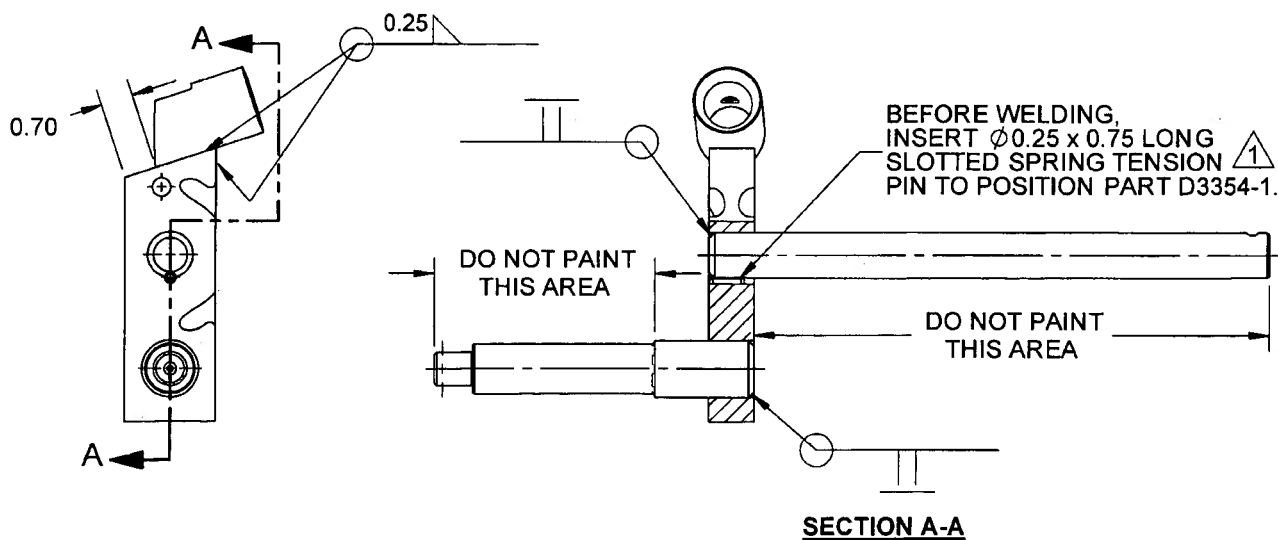
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CHECKED <i>lb</i>	APPROVED <i>MP</i>	DRAWING NO. LEFT ARM WELDMENT	REV. C SHEET 1 OF 7
DATE 07.12.06		TITLE D3354	SCALE 1:4
REV	DATE	DESCRIPTION	
A	04.12.13	NEW ISSUE	
B	07.02.02	REVISED DIMENSIONS	
C	07.12.06	CHANGE TOLERANCE ON D3354-7 LEFT ARM PLATE HOLE FOR D3354-3 WHEEL SHAFT	

RELEASED
07/12/07 *MP*



**D3354-042 MIRROR
ARM WELDMENT**

D3354-041 LEFT ARM WELDMENT



NOTES:

- 1) POSSIBLE SUPPLIER: SPAENAU, P/N TP-134
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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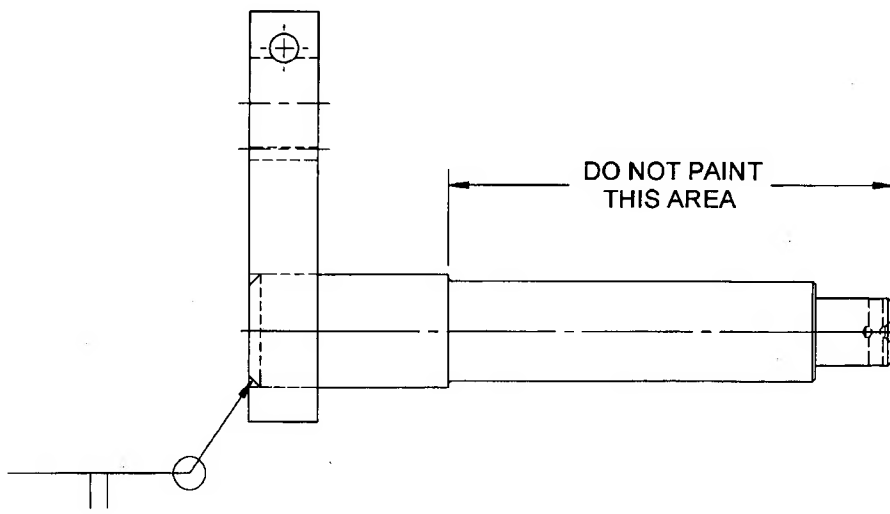
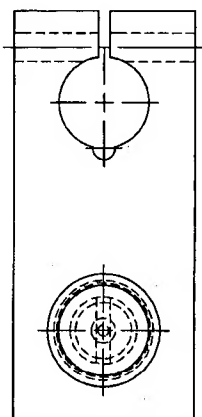
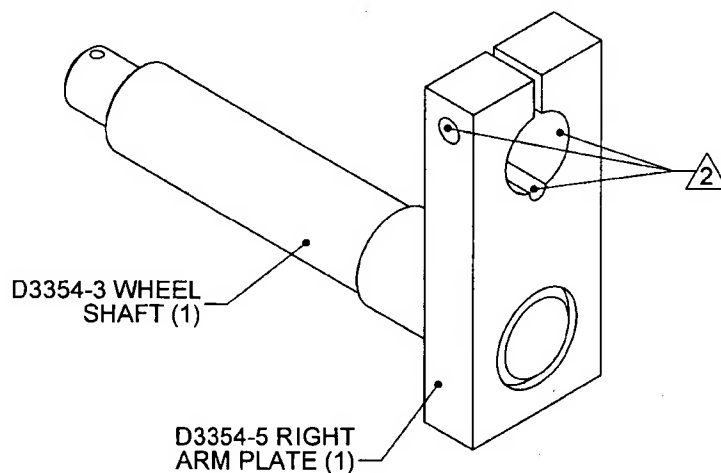
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
01/12/07 *WJ*



D3354-043 RIGHT ARM WELDMENT

NOTES:

- 1) WELD PER DART QSI 004
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005.4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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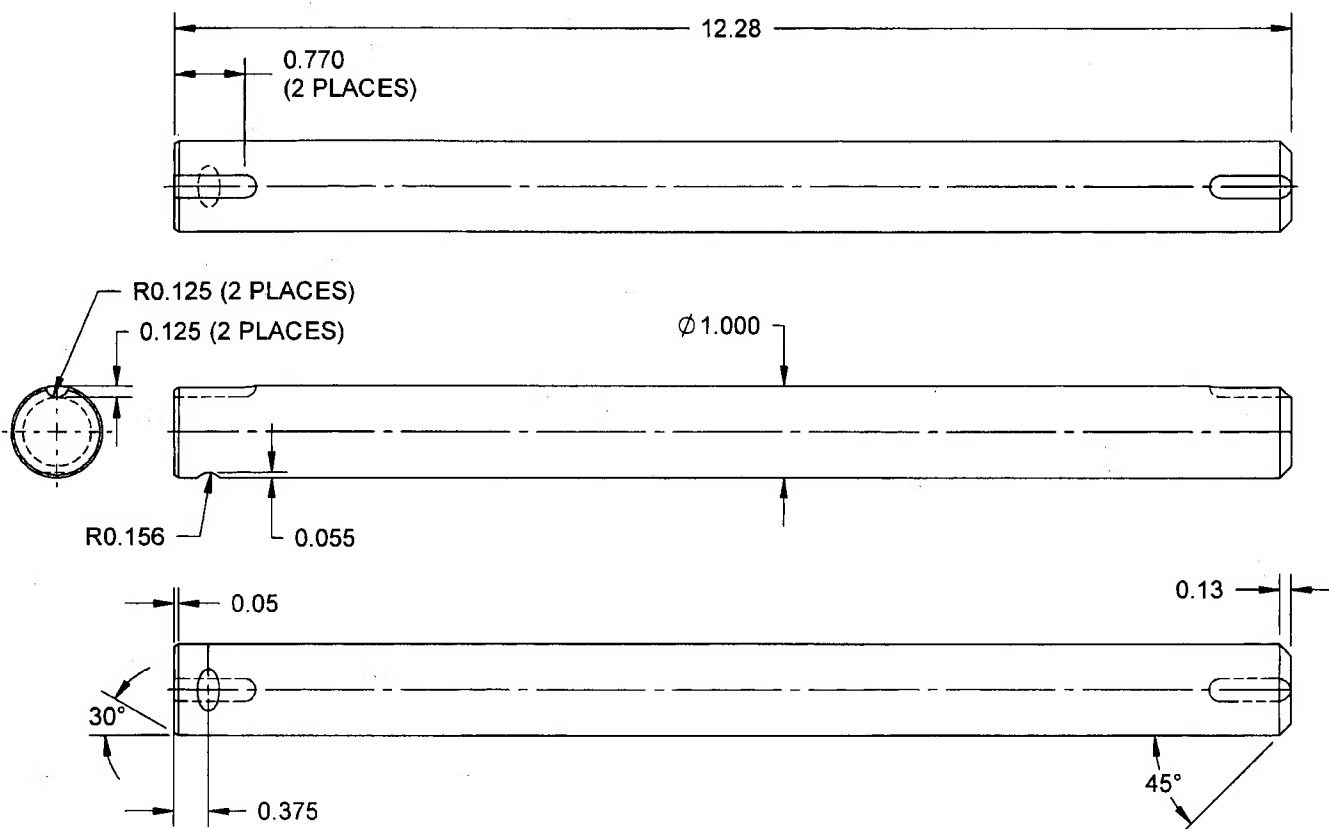
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CHECKED <i>JP</i>	APPROVED <i>JP</i>	DRAWING NO. D3354	REV. C SHEET 3 OF 7
DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
01/12/07 *W*



D3354-1 INNER SHAFT

NOTES:

- 1) MATERIAL: AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR, ϕ 1.250 (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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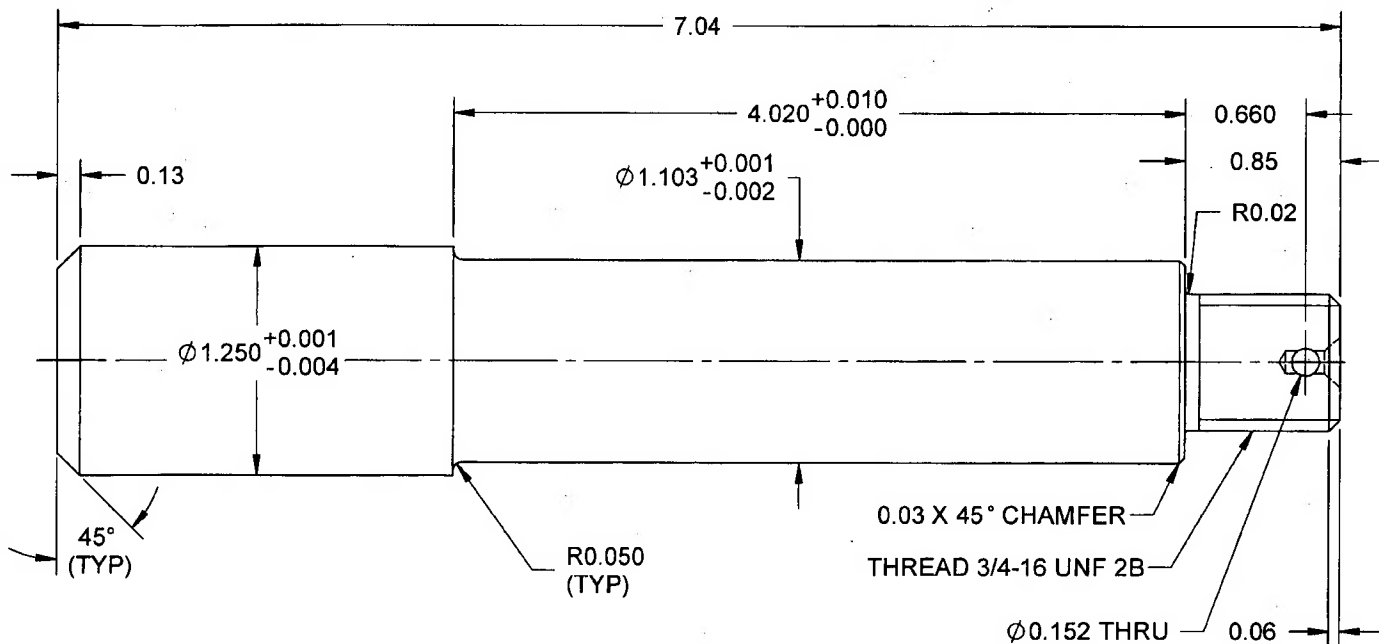
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED
07.12.07 *WP*



D3354-3 WHEEL SHAFT

NOTES:

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91
OR UNS#-G41400 ROUND BAR, $\phi 1.250$ (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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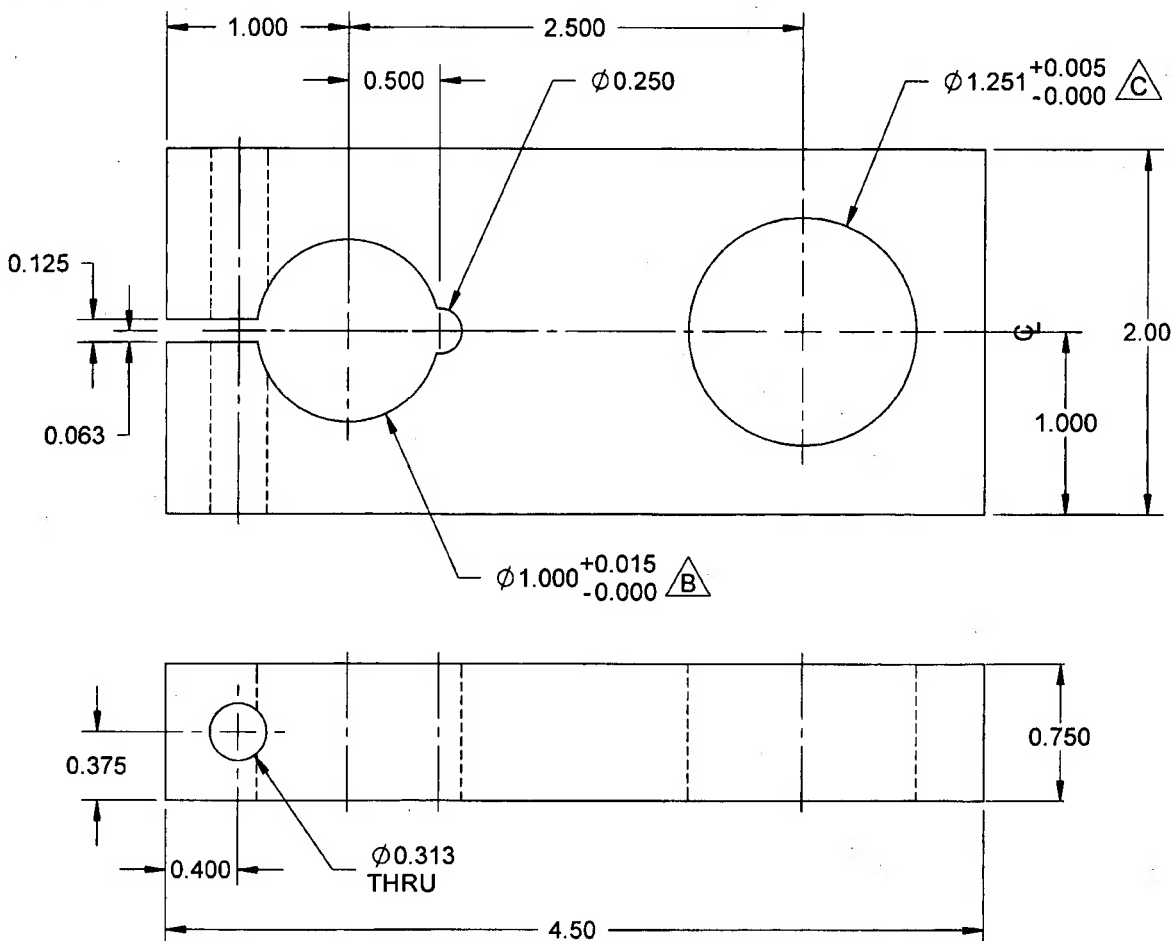
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DATE 07.12.06	TITLE LEFT ARM WELDMENT	SCALE 1:1

RELEASED
07/12/07 *[Signature]*



D3354-5 RIGHT ARM PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 0.75 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

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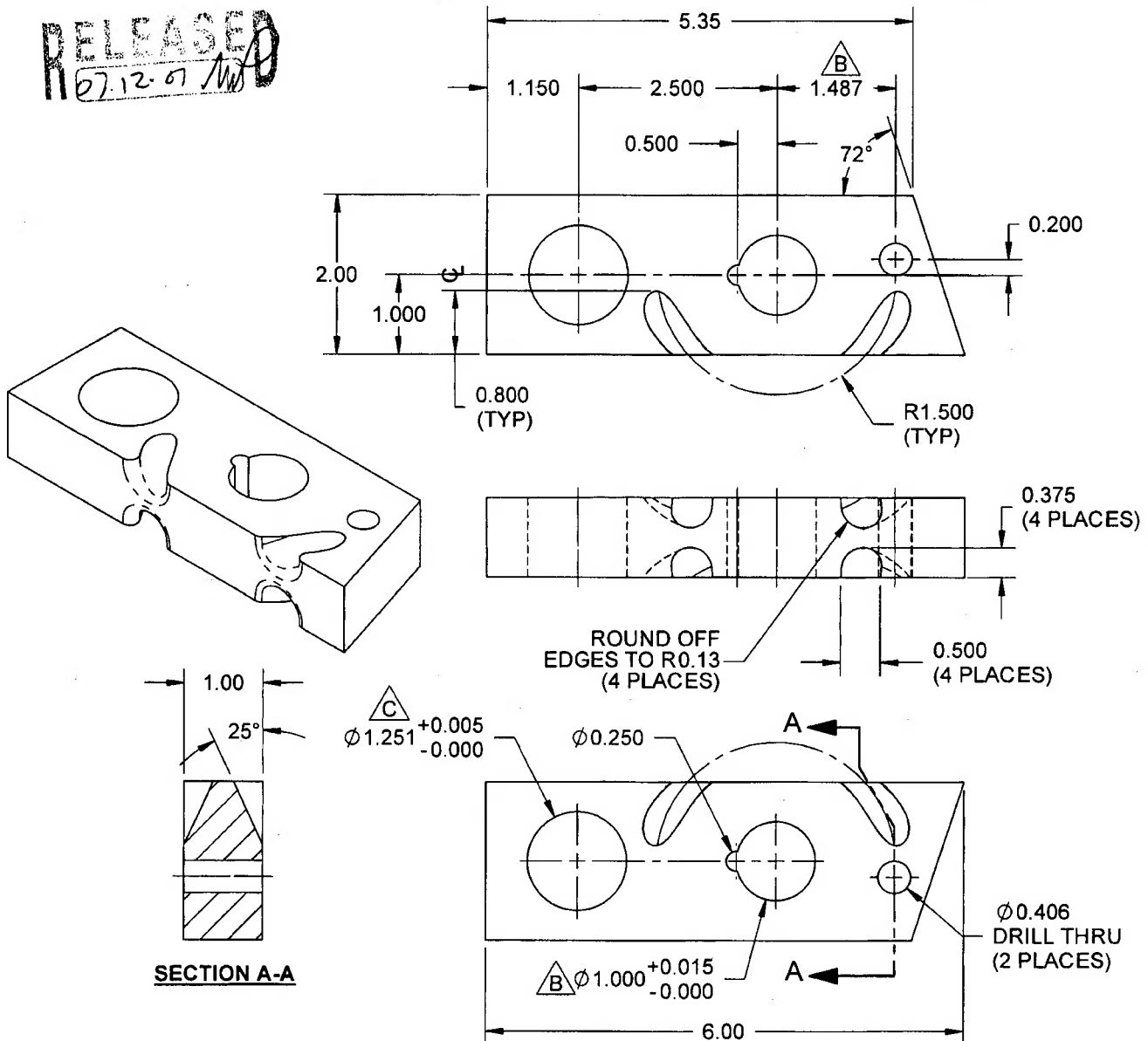
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:2

RELEASED
07.12.07 *MA***D3354-7 LEFT ARM PLATE****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570 OR CSA G40.21, 38W/44W/50W/60W/70W, 1.00 THICK MILD STEEL BAR (REF. DART SPEC. M1010-B)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

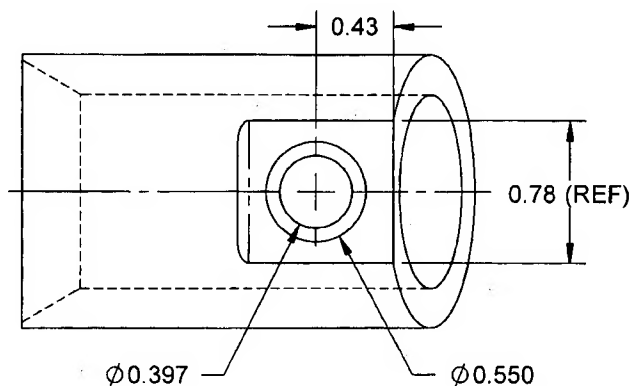
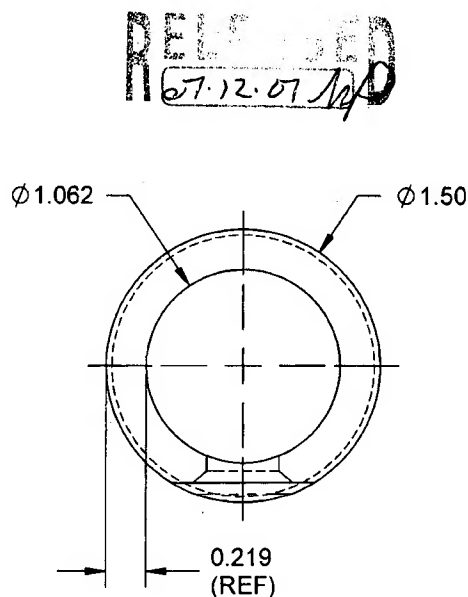
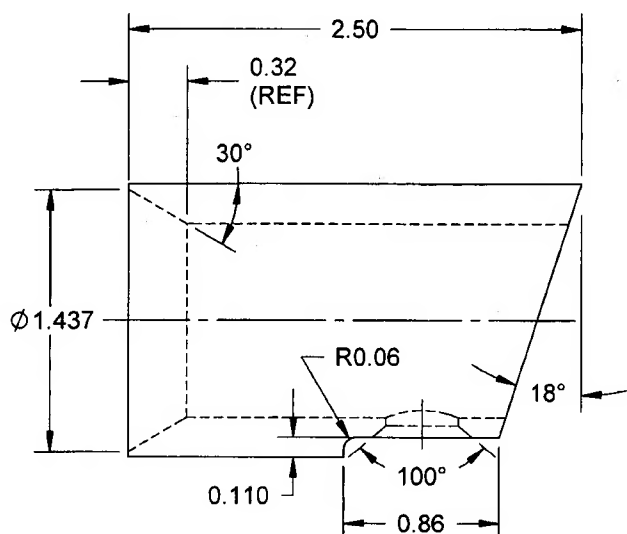
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DATE 07.12.06		TITLE LEFT ARM WELDMENT	SCALE 1:1



D3354-9 HANDLE SOCKET

NOTES:

- 1) MATERIAL: AISI 1010-1025 SEAMLESS ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, (REF. DART SPEC. M1020TR1.250W.219)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
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